

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011545**Date Inspected:** 10-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhu Zhong Hai**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

**Segment 7CW**

This QA Inspector performed a preliminary random visual inspection after the grit blast of the internal components of the side plate, bottom plate and corner assemblies of this segment. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection.

**Bay#19**

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

-(BP3017-001-003)

-(BP026-015-003)

**Bay#13**

SMAW welding of weld joint SSD20A-PP101-253, 252 located on Segment 11CE. Welder is identified as 044772 (4G). ZPMC QC is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

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SMAW welding of weld joint SSD20-PP101-253, 252 located on Segment 11CE. Welder is identified as 044772 (4G). ZPMC QC is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

SMAW welding of weld joint SSD12-PP100-223, 253 located on Segment 11BW. Welder is identified as 067656 (4G). ZPMC QC is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

SMAW welding of weld joint SSD14-PP101-252, 222 located on Segment 11AW. Welder is identified as 067656 (4G). ZPMC QC is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

FCAW welding of weld joint SSD20-PP101-227, 257 located on Segment 11CE. Welder is identified as 058551 (2G). ZPMC QC is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint SSD20A-PP101-226, 256 located on Segment 11CE. Welder is identified as 051356 (2G). ZPMC QC is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint SSD29-PP95.5-211~244 located on Segment 11AE. Welder is identified as 055564 (3F). ZPMC QC is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2133.

FCAW welding of weld joint SSD29-PP95.5-171~206 located on Segment 11AE. Welder is identified as 055564 (2F). ZPMC QC is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

FCAW welding of weld joint SSD29-PP96.5-059~094 located on Segment 11AW. Welder is identified as 050242 (2F). ZPMC QC is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

Unless otherwise noted, all observed on this date appeared to generally comply with applicable contract documents.

### **Summary of Conversations:**

No relevant conversations.

### **Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Patel,Hiranch	Quality Assurance Inspector
<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer

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